

Work Order ID 94173-1

November-30-12 9:37:30 AM

SPLIT

94173

96269

Page 1

Item ID: D3414-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug Assembly

26

Start Date: 11/30/12 Start Qty: 16.00

16

10

Cust Item ID:

Required Date: 12/14/12 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-12-03 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3414 | Rev C | | | | | | | | |
| 100 | | 0.00 | | | | 26 | | | 12-12-11 |
| *100* | | | | | | 16 | 0 | | 12-12-10 |
| Waterjet | Memo | 0.00 | | | | | | | |
| FLOW CNC Waterjet | 1-Cut as per Dwg D3414-1 | | | | | | | | |
| 304, 100" | Dwg Rev: <u>C</u> | | | | | | | | |
| | Prog Rev: <u>C</u> | | | | | | | | |
| | 2-Deburr if necessary | | | | | | | | |
| 110 | QC2- Inspect parts off machine FAI/FAIB | 0.00 | | | | 26 | | | 12-12-11 |
| *110* | | | | | | 16 | 0 | | 12-12-10 |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

*was closed/costed
lugs D3414-1 adj'd to mil
pulled on 96269*

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Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug Assembly

Start Date: 11/30/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 12/14/12 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***




QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|---|
| 120 *120* QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | | | | | |  12/17/14 |
| 130 *130* Brake NC Brake NC | Memo 1-Deburr 2-Form using DT8254 as per Dwg D3414 | 0.00 0.00 | | | | | | |  12/17/14 |
| 140 *140* Large Fab Large Fab | Memo 1- Weld using location Jig DT9625 as per Dwg D3414 A/R S.S. welding rod Batch: 1116577 | 0.00 0.00 | | | | | | |  12/17/14 |

(26) 12-12-11

26

SA 12/14/17

(16) 13-1-2

PD

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Item ID: D3414-041

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug Assembly

Start Date: 11/30/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 12/14/12 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

150

QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:10
460
9:40

16 & 13-1-4

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Item ID: D3414-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Lug Assembly

Stop ***NS2***

Start Date: 11/30/12 Start Qty: 16.00

16

Cust Item ID:

Required Date: 12/14/12 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

Box of 11-1310101

190

Identify as per dwg & Stock Location: **SI 472** 0.00

190

Packaging

Memo

0.00

Packaging

Box SP 13-01-07

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MF 13-07-07

Picklist Print

November-30-12 9:37:30 AM

Page 1

Work Order ID: 94173

Parent Item: D3414-041

Parent Item Name: Lug Assembly

Start Date: 11/30/12

Required Date: 12/14/12

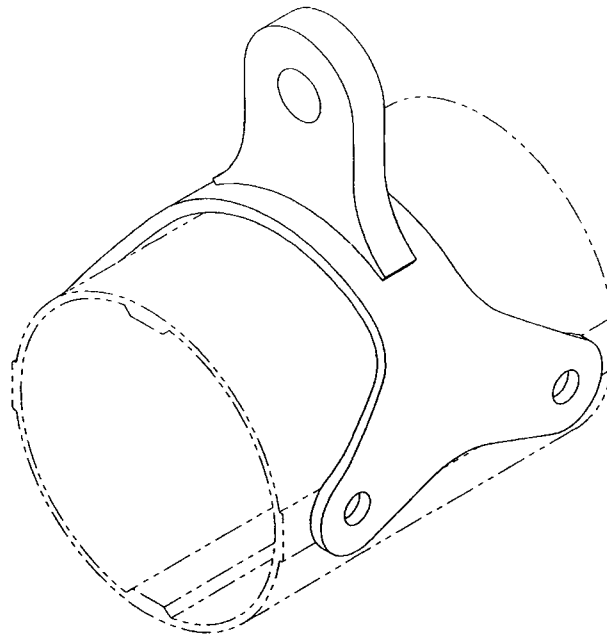
Start Qty: 16.00

Required Qty: 16.00

Comments: IPP A05.09.13New issueKJ/JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|-----------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|-------------|
| M304S12GA 304/316 0.100" Sheet | | Purchased | No | | | 100 | sf | 75.0200 | 0.155 | 248 25 | 5 | | Jm 12-12-10 |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | MAT019 | | 75.02 | | | | | | | |
| | | | | 113062 | | 65.59 | | | | 113062 | | | |
| | | | | 113077 | | 9.43 | | | | | | | |
| D3414-3 Lug | | Manufactured | No | | | 140 | Each | 62.0000 | 1 | 16 | | 12-12-12 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | WA001 | | 62 | | | | | | | |
| | | | | 76228 | | 4 | | | | | | | |
| | | | | 88254 | | 18 | | | | | | | |
| | | | | 92874 | | 40 | | | | 16 | | | |

| ITEM No. | QTY. -041 | PART NUMBER | DESCRIPTION |
|----------|-----------|-------------|--------------|
| 1 | X | D3414-041 | LUG ASSEMBLY |
| 2 | 1 | D3414-1 | LUG BRACKET |
| 3 | 1 | D3414-3 | LUG |



D3414-041 LUG ASSEMBLY

94173 MJS
12-12-03

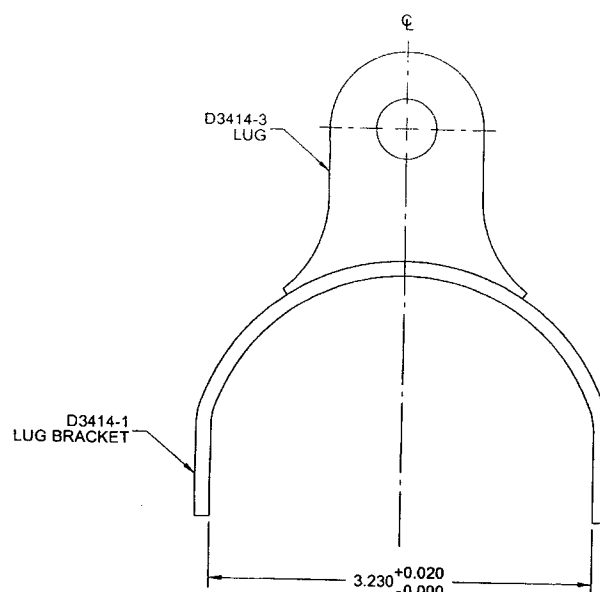
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5/16/06/14

NOTES:

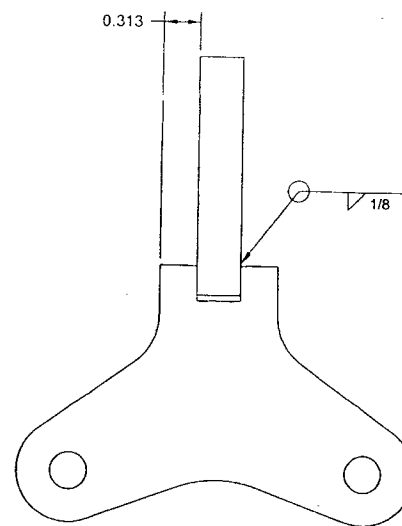
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

| | | | |
|------------|---|---|--------------|
| C | BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (2N A7-3) | CP | 09.06.17 |
| B | DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20. | AJS | 08.09.23 |
| A | NEW ISSUE | CP | 05.03.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CP | | |
| CHECKED | CP | DRAWING NO. | REV. C |
| MFG. APPR. | CP | D3414 | SHEET 1 OF 3 |
| APPROVED | CP | TITLE | SCALE |
| DE APPR. | CP | LUG ASSEMBLY | NTS |
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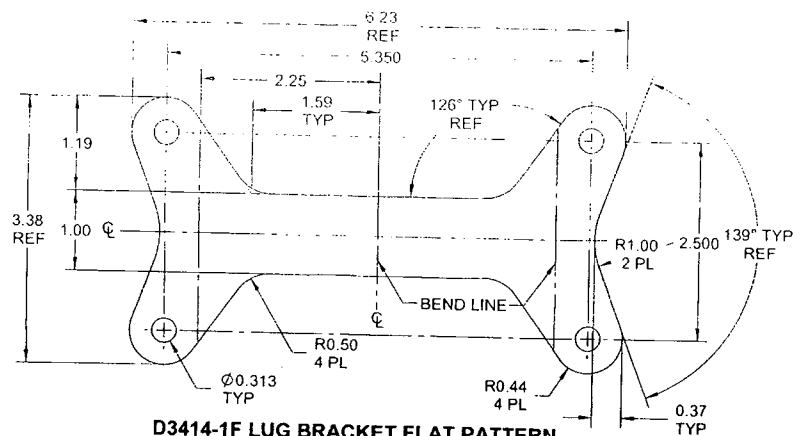


D3414-041 LUG ASSEMBLY

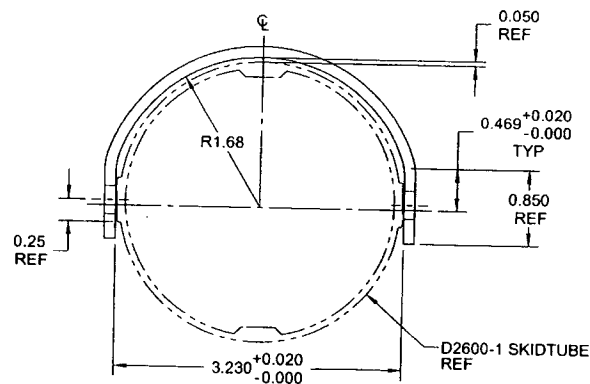


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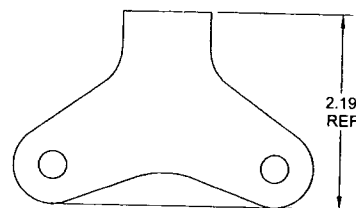
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|------------|----------|--|--------------|
| DESIGN | CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CP | | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D3414 | SHEET 2 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LUG ASSEMBLY | NTS |
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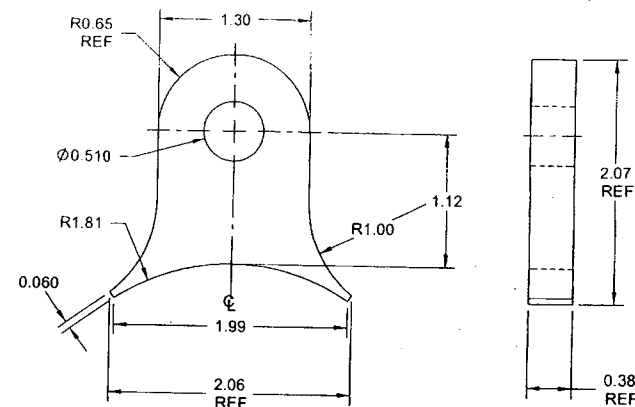
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

NOTES:

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX

-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: N/A



RELEASED

| | | | |
|------------|----------|---|--------------|
| DESIGN | QP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | CP | | |
| CHECKED | | DRAWING NO. | REV. C |
| MFG. APPR. | | D3414 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LUG ASSEMBLY | NTS |
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